







Work Order ID 64791

Friday, December 17, 2010 7:55:20 AM


Page 1

Item ID:	D3246-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Mounting Bracket				Stop	
Start Date:	12/16/2010	Start Qty:	6.00	Cust Item ID:		
Required Date:	1/19/2011	Req'd Qty:	6.00	Customer:		
Reference:						

Approvals:	Process Plan:		Date:	10/12/17	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	


Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3246	Rev A1


100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg Dsi9279 <input type="checkbox"/> Dwg Rev: A1 <input type="checkbox"/> Prog Rev: A1 <input type="checkbox"/> 2-								
2624.050	Deburr if necessary								

1311-1-3



110	QC2- Inspect parts off machine FAI/FAIB	0.00							
									
QC	Memo	0.00							
Quality Control									

1311-1-3

120	QC8- Inspect parts - second check	0.00							
									
QC	Memo	0.00							
Quality Control									

8/10/103



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64791

Friday, December 17, 2010 7:55:20 AM



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Item ID: D3246-041

Accept



Setup Start



Revision 'D':

Item Name: Mounting Bracket

Stop



Start Date: 12/16/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 1/19/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC Brake NC	NC BRAKE Memo Deburr Form as per Dwg D3246 C'sink as per Dwg D3246	0.00 0.00				(9)	X		PTO
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(X9)			
150 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				X9			

SB 12/16/10
EP 12/01/06

Silbuck

M 12/16/10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D3246-041 PAR #: _____ Fault Category: Small Fob NCR: (Yes) No DQA: _____ Date: 11/01/28
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: (Yes) Date: 11/01/28

NCR: <u>64791</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/01/10</u>	<u>130</u>	<u>at the set-up 1 probe</u> <u>was contaminated to</u> <u>deep</u> <u>R.C process / Lack of Attention</u>	<u>(Signature)</u> <u>Q3I42</u>	<u>Scrap - destroy</u> <u>no Pen/ku</u> <u>Qty (1)</u>	<u>ES</u> <u>11/01/10</u>	<u>S</u> <u>11/01/10</u>	<u>(Signature)</u> <u>Q3I42</u>	<u>(Signature)</u> <u>11/01/10</u>

NOTE: Date & initial all entries

Work Order ID 64791

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Friday, December 17, 2010 7:55:20 AM

Item ID: D3246-041

Accept



Setup Start



Revisor ID:

Stop



Item Name: Mounting Bracket

Start Date: 12/16/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 1/19/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

170

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Install Nut Plates as per Dwg D3246

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64791

Friday, December 17, 2010 7:55:20 AM



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Item ID: D3246-041

Accept



Setup Start



Revisor ID:

Stop



Item Name: Mounting Bracket

Start Date: 12/16/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 1/19/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: *Qty*

0.00



Packaging

Memo

0.00

Packaging

Run/Stop 20 (9)

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/01/2010**mf
11-01-20*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, December 17, 2010 7:55:24 AM

Page 1

Work Order ID: 64791

Parent Item: D3246-041

Parent Item Name: Mounting Bracket



Start Date: 12/16/2010

Required Date: 1/19/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 06-06-22 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21059L3 Nut Plate		Purchased	No			110	Each	54.0000	4	24			
<div> <div> <u>Location</u> ST301 114718 116158 </div> <div> <u>Loc Qty</u> 54 6 48 </div> <div> <u>Loc Code</u> </div> </div>													
M2024T3S.050 2024-T3 .050 sheet		Purchased	No			170	sf	92.3847	0.3097	1.956			
<div> <div> <u>Location</u> MAT22 111381 113189 114968 4894 </div> <div> <u>Loc Qty</u> 92.3847 11.89 0.3947 80.1 5 </div> <div> <u>Loc Code</u> </div> </div>													
MS20426AD3-3 Rivet		Purchased	No			170	Each	3,847.000	8	48			
<div> <div> <u>Location</u> ST316 19099 </div> <div> <u>Loc Qty</u> 3847 3847 </div> <div> <u>Loc Code</u> </div> </div>													

EP 11/01/10
M116582 (152)

21
B11-1-3

(18)

4894
EP 11/01/10
72

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

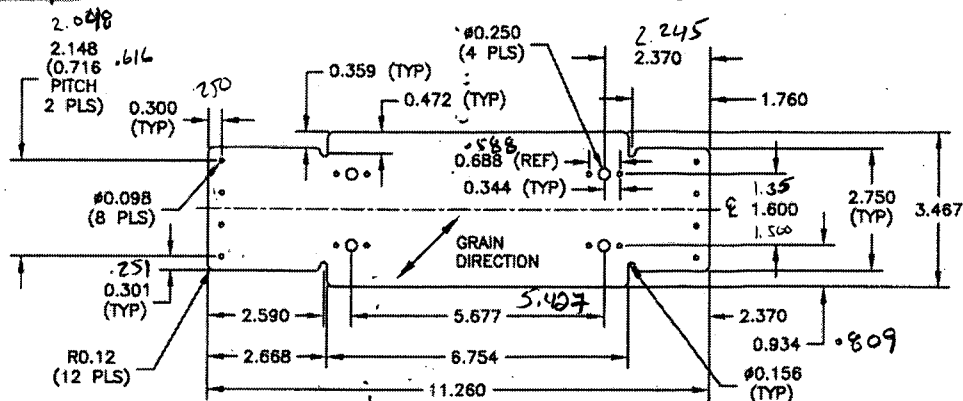
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

• **NOTE:** Date & initial all entries

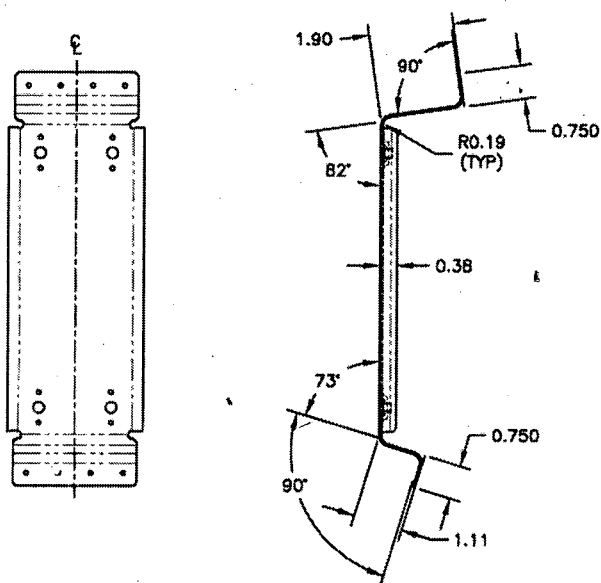


DESIGN JH	DRAWN BY JF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JH	APPROVED JH	DRAWING NO. D3246	REV. A SHEET 1 OF 1
DATE 04.04.21		TITLE MOUNTING BRACKET	SCALE 1:4
A	04.04.21	NEW ISSUE	
AI	04.06.16	CHANGE RIVET; ADDED C SINK	

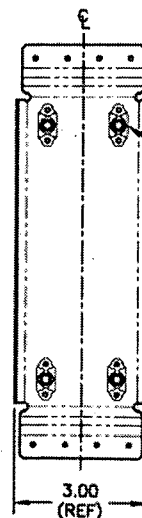
RELEASED
04.05.07



D3246-1 FLAT PATTERN



D3246-1 BEND DETAIL



D3246-041 ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69791

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.050 THICK (REF. DART SPEC. M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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